

Date: Wednesday, 12/03/2008 11:37:06 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLOOR PROCTOR AFT LH
<b>Job Number</b> :	37890		
<b>Estimate Number</b> :	11228		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32813
<b>This Issue</b> :	12/03/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3281 REV B
<b>First Issue</b> :	1 / 1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37826	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	THERMOFORMING	<b>Due Date</b> :	19/03/2008
<b>Written By</b> :		<b>Qty:</b>	5
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev: A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Est Rev. C 08.02.06 To reflect updated Dwg. DL		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	F6006 701	lexan black
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**Comment:** Qty.: 4.0000 sf(s)/Unit Total: 20.0000 sf(s)  
 lexan black

M 106751

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/03/19 X5

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 009

Dwg. Rev. CFolio Rev. B

BB 08/03/24 X5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/03/24 X5

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/03/25 X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/03/2008 11:37:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 37890

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

08/03/25 (X8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/26 (X5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/3/26

(5X) SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



MF

08-03-27

U

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

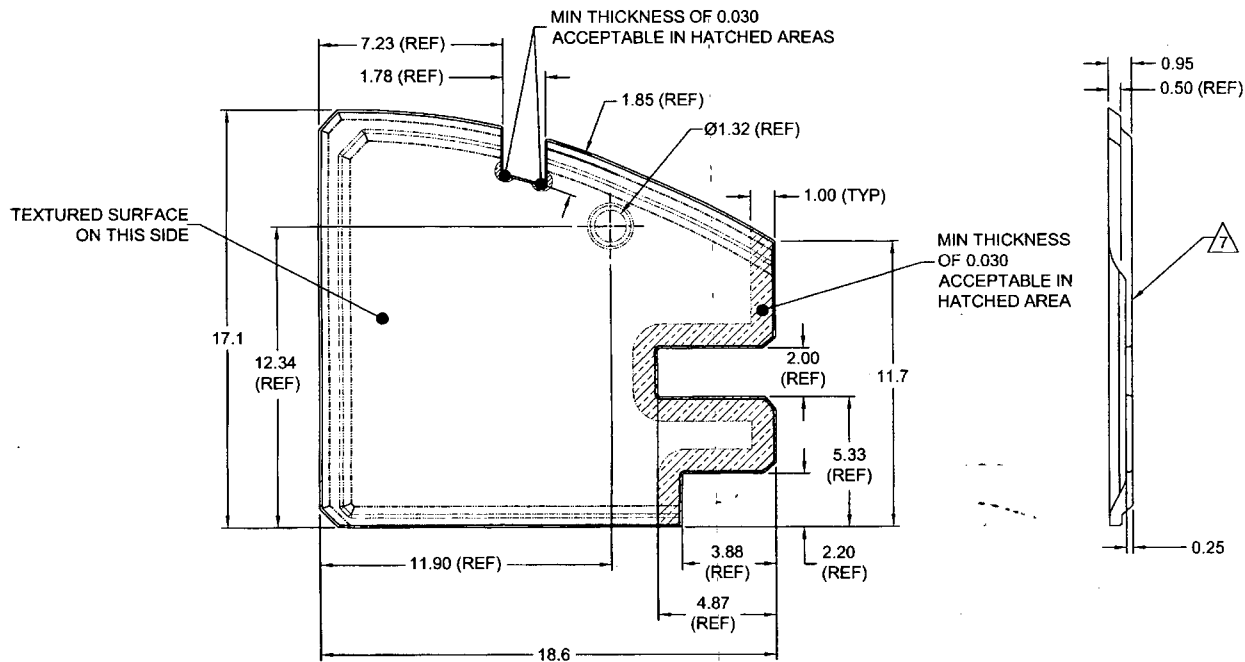
NOTE: Date & initial all entries

RELEASED  
07-11-06

# D3281-1 FLOOR PROTECTOR

## D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

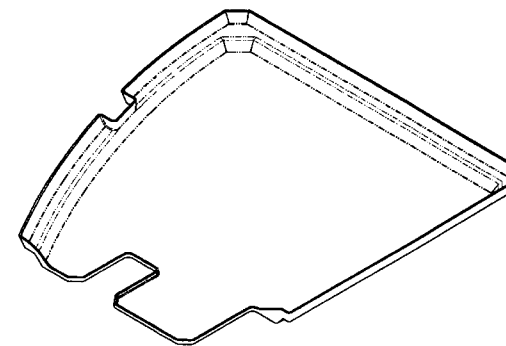
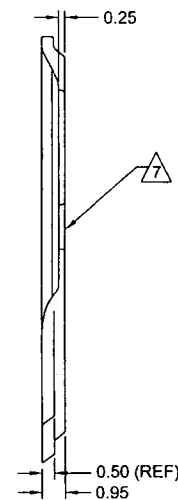
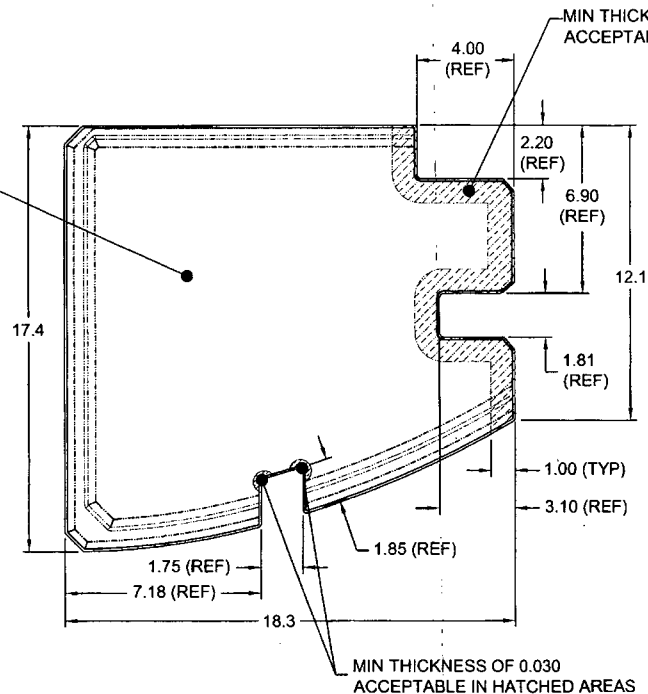


C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	GP		
DRAWN	LE		
CHECKED	PA		
MFG. APPR.	ST		
APPROVED	ST		
DE APPR.	ST		
DATE	07.10.09		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3281	REV. C SHEET 1 OF 3
TITLE FLOOR PROTECTOR	SCALE NTS
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TEXTURED SURFACE  
ON THIS SIDE



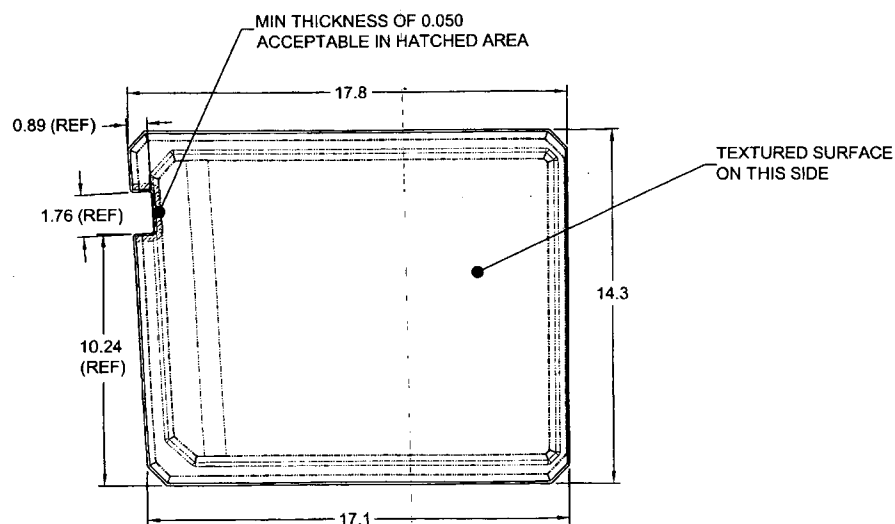
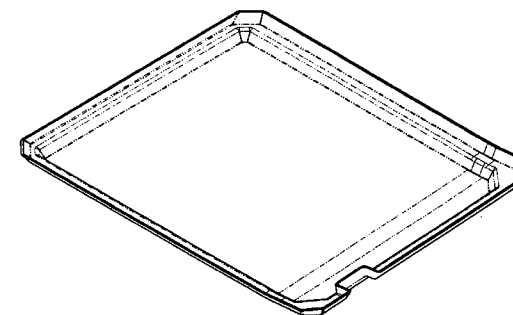
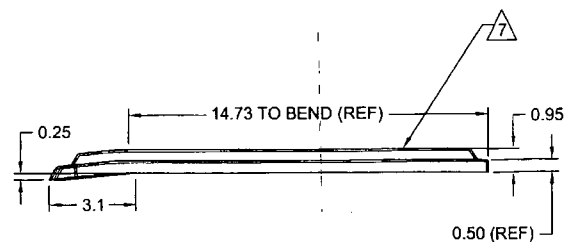
**RELEASED**  
07-11-06

**D3281-2 FLOOR PROTECTOR**

**D3281-2 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO.	REV. C
MFG. APPR.	BL	D3281	SHEET 2 OF 3
APPROVED	100	TITLE	SCALE
DE APPR.	100	FLOOR PROTECTOR	NTS
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RELEASED  
07.11.06

**D3281-3 FLOOR PROTECTOR**  
**(D3281-4 OPPOSITE)**

**D3281-3/-4 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO.	REV. C
MFG. APPR.	WJ	D3281	SHEET 3 OF 3
APPROVED	JL	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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DART AEROSPACE LTD	WORK ORDER: 37890
Description: Floor Protector AFT Ltt.	Part Number: D32813
Inspection Dwg: 32813 Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	BB
Acceptable shape definition	BB
Acceptable texture retention	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

(Step 6) Trimming  
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	.1	17.755	✓			
14.3	.1	14.275	✓			
17.1	.1	17.12	✓			
.95	.030	.967	✓			

Measured by: BB  
Date: 08/03/25

Audited by: S  
Date: 08/03/25

Prototype Approval: a/  
Date: 17

Rev	Date	Change	Revised by	Approved
		New Issue		